

Work Order ID 141499

Friday, February 05, 2016 8:05:34 AM

141499

Please cut ASAP

Feb 22 - 23

Page 1

Item ID: 646.3511

Revision ID:

Item Name: Strut

Start Date: 2/3/2016 Start Qty: 4.00

Required Date: 2/3/2016 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: FEB 08 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3500

N/C 3

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg

Dwg Rev: N/C 3

Prog Rev: N/C 3

2-Deburr if necessary

(24)

2/16/22/22

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

(24)

2/16/22/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		☐ OTHER : _____							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 141499

Friday, February 05, 2016 8:05:34 AM

141499

Page 4

Item ID: 646.3511 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut
Start Date: 2/3/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/3/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							DAS 41 9-89
220		0.00				1			16-3-22
SprayPaint	Memo								
Spray Painting	Prime as per dwg (see note 3)								
	Batch: <u>133399</u>								
230	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
230		0.00				24			MAR 23 2016
QC	Memo								
Quality Control									
240		0.00							
240		0.00				24			MAR 31 2016
Packaging	Memo								
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								

CCK 108A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

Work Order ID 141499

Friday, February 05, 2016 8:05:34 AM

141499

Page 5

Item ID: 646.3511

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 2/3/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21 - Final Inspection - Work Order Release

0.00

250

QC

Memo

0.01

MCS APR 01 2016

Quality Control

MAR 31 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, February 05, 2016 8:05:38 AM

Page 1

Work Order ID: 141499

141499

Parent Item: 646.3511

646.3511

Parent Item Name: Strut

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA		Purchased		No			sf	188.6800		0.117053			
-----------	--	-----------	--	----	--	--	----	----------	--	----------	--	--	--

M304S16GA

304/316 Sheet .063

216/02/22

Location	Loc Qty	Loc Code
MAT019	188.68	
m133511	28.68	
m13406	64	
m134158	96	

M304TR0.500W.049		Purchased		No			f	264.1901					
------------------	--	-----------	--	----	--	--	---	----------	--	--	--	--	--

M304TR0.500W.049

304 RD Tube .500 x .049W

2.507368
~~2.507368~~
20.92105

216 16/03/08

Location	Loc Qty	Loc Code
GA002	264.190061	
M127937	1.1741	
M128833	0.00003	
M130099	15.895	
M132872	247.120931	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04274

SHEET 1 OF 1

DWG NO. 646.3500

REV: NC

PREPARED BY J. SOTO

DATE: 12/02/2013

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT

APPROVED BY:

ENGR *[Signature]*

MFG

Dawn Barber

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED DELTA NOTE 1 & 2.

SHEET 1, ZONE A1 IS:

IS

NOTES:

- 1 MATERIAL: AISI 304/ 316 SS SHEET .062 THK
(REF DART SPEC. M304S16GA)
- 2 MATERIAL: AISI 304/316 SS 0.500 OD X 0.049 WALL
(REF DART SPEC. M304TRO.500W0.049)
ENSURE SEAMLESS TUBE IS USED
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
4. DEBURR AND BREAK ALL SHARP EDGES
5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD

1414 99 ML5
16-02-08

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02440

SHEET 1 OF 1

DWG NO. 646.3500 REV: NC PREPARED BY S. HUFF / DATE 06/08/09 EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE:

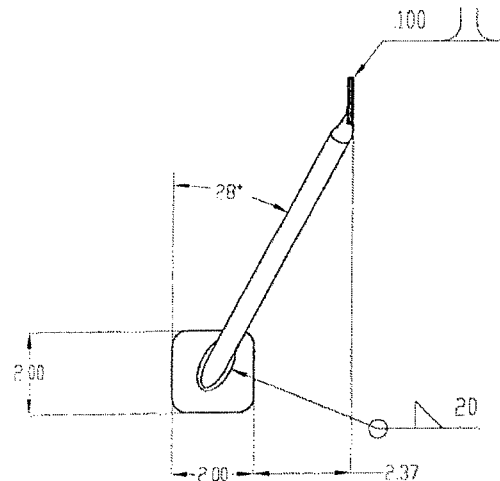
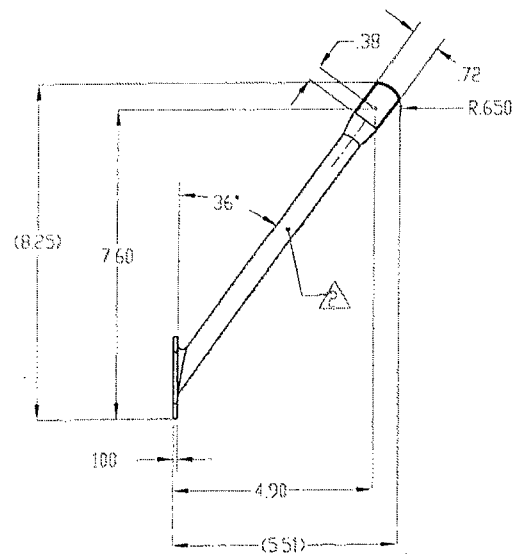
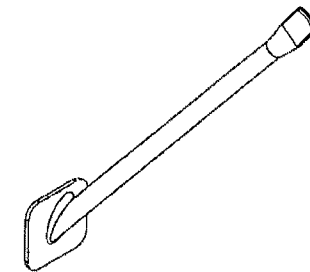
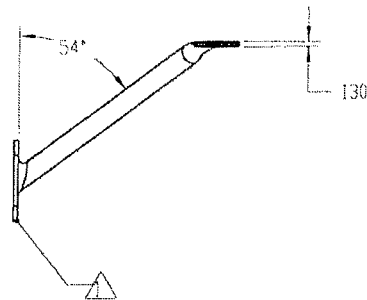
STRUT

APPROVED BY: ENGR *[Signature]* MFG *[Signature]* QC *[Signature]* EFF: *[Signature]* CURRENT ORDER AND STOCK

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED GEOMETRY TO ACCOMMODATE NEW EXISTING AIRCRAFT PROVISIONS

SHEET 2 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

02197

SHEET 1 OF 1

DWG NO. 646.3500

REV: N/C

PREPARED
BY

S. HUFF

DATE: 01/05/09

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE:

STRUT

APPROVED BY:

ENGR

MFG

QC

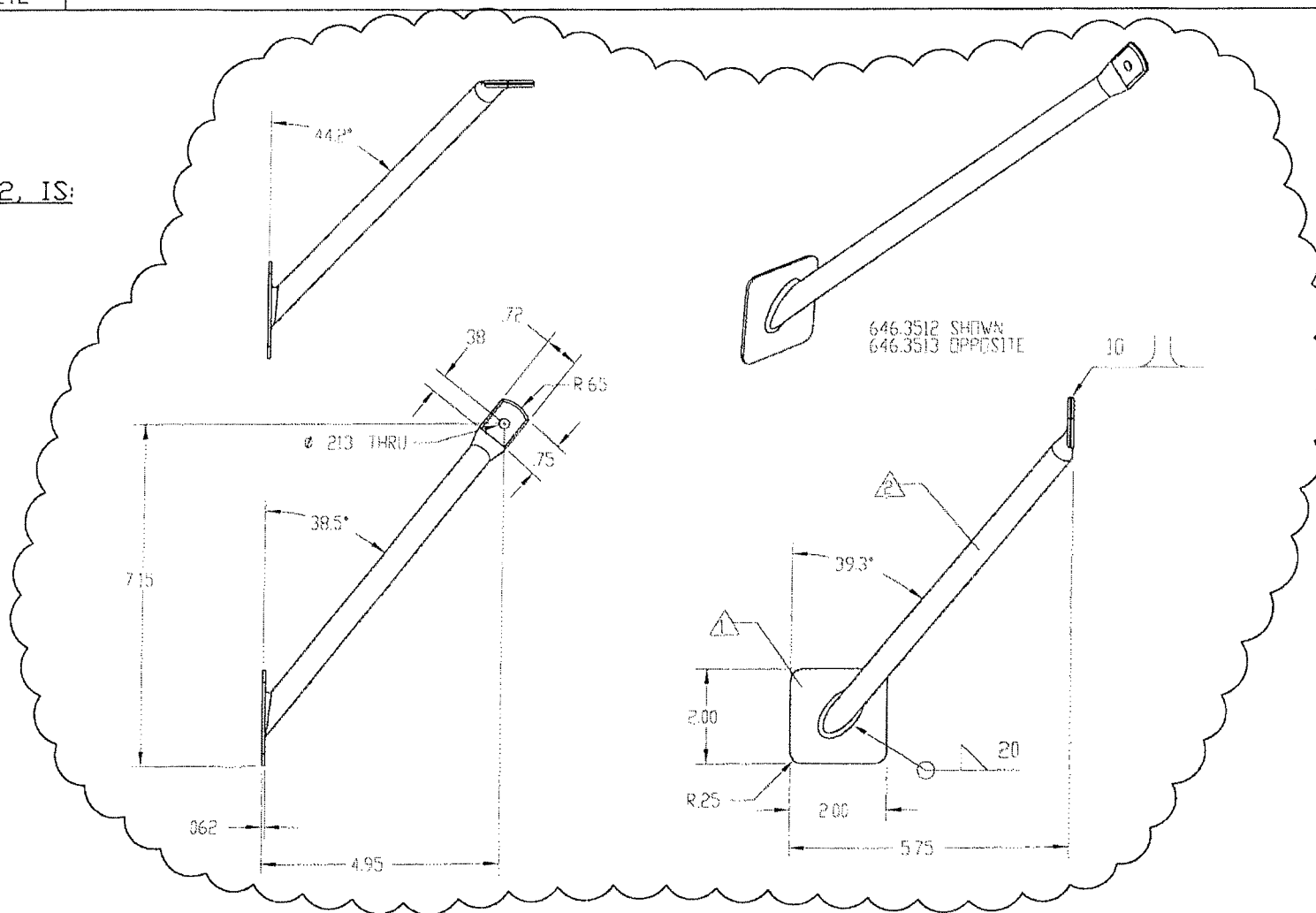
EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED ANGLE OF 646.3512 & 646.3513 FOR BETTER FITMENT

SHEET 2, IS:



DOCUMENTS EFFECTED:

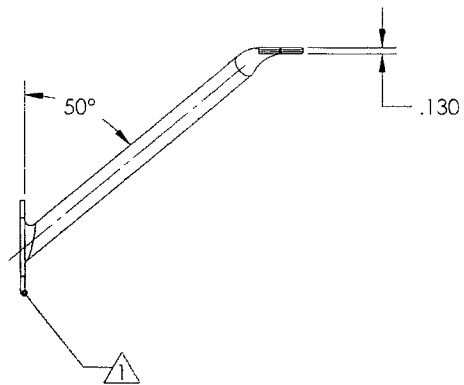
☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

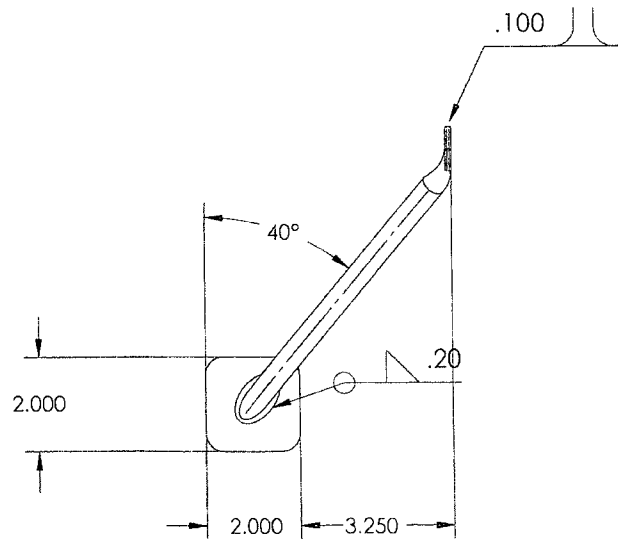
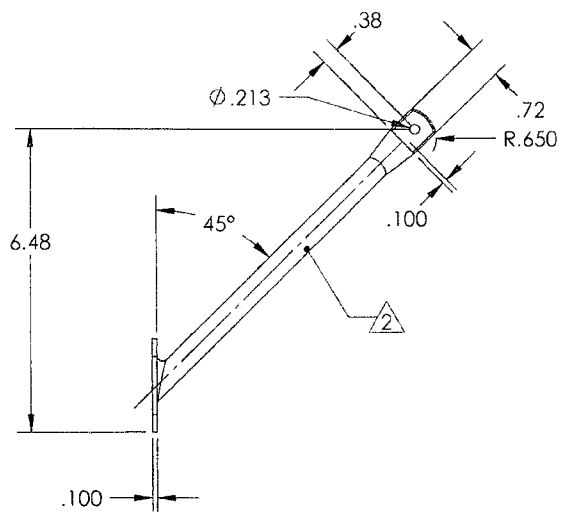
DER REVIEW REQUIRED
☐ YES ☒ NO

			646.3513	STRUT	△△△	△△
			646.3512	STRUT	△△△	△△
			646.3511	STRUT	△△△	△△
			646.3510	STRUT	△△△	△△
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY				PARIS LIST		
NEXT ASSY (S)		ORIGINAL DATE: 02-25-06 DRAWN BY: J. HENDER H. ANDERSON, P. HED QUANTITY: 1000 P. HED CONTRACT NO:				
646.4000		APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-2512 (760)724-5300				
		STRUT				
		U.S. & CANADIAN STANDARDS DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16" DECIMALS: .005 3/16" DECIMALS: .005 FRACTIONS: .005				
REV	CAGE CODE	DWG. NO.	646.3500		REV	
	07M26				N/C	
SCALE NONE					SHEET	1 OF 2

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
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646.3512 SHOWN
646.3513 OPPOSITE



ORGAN: SKT (P) (M) (P) DE 21-06 DRAWN BY: J. C. HOFF E. ANDERSON P. BRANC DRAWING APPROVAL: P. BRANC DE 21-06 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNITS: DIMENSIONS SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET CODE: B DWG. NO: 646.3500 SCALE: NONE	REV: NAC SHEET: 2 OF 2
STRUT			